

# Work Order ID 83264

April-16-12 1:35:49 PM

ASAP

\*83264\*

Page 1

Item ID: D3275-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Crossbolt Spacer

Stop \*NS2\*

Start Date: 16/04/2012 Start Qty: 80.00

\*80\*

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 80.00

\*80\*

Customer:

Reference:

Approvals:

Process Plan:

ML5

Date: 12/04/12

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3275

Rev A1

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA469 and Dwg D3275

SC  
12/04/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

SC  
12/04/12

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

SA 12/4/12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*83264\***

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**\*N900040100\***

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Revision ID:

Item Name: Crossbolt Spacer

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 80.00

**\*80\***

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 80.00

**\*80\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: LG

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

84 90 12-05-01

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/5/2

12-05-2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 83264

\*83264\*

Parent Item: D3275-1

\*D3275-1\*

Parent Item Name: Crossbolt Spacer

Start Date: 16/04/2012

Required Date: 23/04/2012

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A04.10.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased		No		100	f	186.1860	0.2666	22.45053			

\*M6061T6T0 3125W 058\*

ALUM TUBE .3125 x .058w

\*\*

SC 12/04/12

Location

Loc Qty

Loc Code

MAT013

186.186

116793

1.667

116939

19.722

117400

16.9

- 118438

14.584

119678

91.271

- 120654

42.042

12

12

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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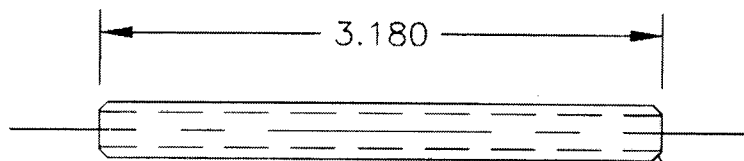
**NOTE:** Date & initial all entries





DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3275	REV. A SHEET 1 OF 1
DATE 04.03.10		TITLE CROSS BOLT SPACER	SCALE 1:1
A	04.03.10	NEW ISSUE	
AI	<i>UP</i> 07.10.19	CHANGE MAT'L SPEC	

RELEASED  
04.06.22



0.025-0.030 x 45°  
CHAMFER (TYP)

$\phi 0.313^{+0.010}_{-0.005}$   
 $\phi 0.201^{+0.005}_{0.000}$   
 $\phi 0.197$



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83264 MJS  
12/04/10

### D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6R) M6061T6TO313W.058 AI
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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